

Date: Wednesday, 2/15/2006 11:28:15 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : MOVE CENTER CLAMP HOLES
<b>Job Number</b> : 25812	
<b>Estimate Number</b> : 12290	
<b>P.O. Number</b> :	<b>Part Number</b> : DSI9320
<b>This Issue</b> : 2/15/2006 <b>S.O. No.</b> :	<b>Drawing Number</b> : DSI9320 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 2/15/2006 <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> :	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 2/20/2006 <b>Qty:</b> 2 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est Rev: A New Issue 06-02-15 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	K10008	Bearpaw kit 19" x 24"
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 K10008 Bearpaw kit 19" x 24"

253678

JLM 06.02.16.

2.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

1-Drill &amp; C'Bore as per DSI 9320

2-Deburr

JLM 06.02.16.

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

JLM 06.02.16.

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

JLM 06.02.16.

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP K10008 - KEEPS SAME P/N

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

C406102114 (2)

Date: Wednesday, 2/15/2006 11:28:15 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOVE CENTER CLAMP HOLES

Job Number: 25812

Part Number: DSI9320

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

DP 06/02/16 (2)

Job Completion



CL 06-02-16

## Linda Lacelle

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**From:** David Shepherd [davids@dartaero.com]  
**Sent:** Wednesday, February 15, 2006 10:33 AM  
**To:** Linda Lacelle  
**Cc:** 'Marc Bellavance'; Bill Beckett (E-mail); Jean-Luc Menard (E-mail); pmcdonald@dartaero.com  
**Subject:** Re: Emailing: DSI 9320 with Signatures

Linda,

There is NO CHANGE to the part number of the kit. All we have done is approved a one-off modification to the existing D350-578-011 kit for a customer who couldn't seem to drill his own holes. The kit will still function as a D350-578-011. The only thing we could do is modify the label to say "D350-578-011/K10008 modified per DSI 9320".

David

----- Original Message -----

From: "Linda Lacelle" <llacelle@dartaero.com>  
To: "'David Shepherd'" <davids@dartaero.com>  
Cc: "'Marc Bellavance'" <mbellavance@dartaero.com>; "Bill Beckett (E-mail)" <billb@dartaero.com>; "Jean-Luc Menard (E-mail)" <jeanlucm@dartaero.com>  
Sent: Wednesday, February 15, 2006 6:32 AM  
Subject: RE: Emailing: DSI 9320 with Signatures

> Will this be the new P/N for the kit, once it gets modified?

>

> -----Original Message-----

> From: David Shepherd [mailto:davids@dartaero.com]  
> Sent: Tuesday, February 14, 2006 3:10 PM  
> To: Linda Lacelle  
> Cc: Bill Beckett; pmcdonald@dartaero.com; Marc Bellavance  
> Subject: Fw: Emailing: DSI 9320 with Signatures

>

>

> Linda,

>

> Please see attached approved DSI to modify that bearpaw kit for L3 as  
> requested by Bill.

>

> Marc,

>

> Please initiate ECN for this.

>

> David

>

>

>

75812

## Linda Lacelle

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**From:** Peggy McDonald [pmcdonald@dartaero.com]  
**Sent:** Monday, February 13, 2006 9:18 AM  
**To:** 'Linda Lacelle'  
**Subject:** FW: AS350-B3 Bear Paws

Hi Linda,

I am not sure if you are aware – DART has agreed to counterbore a set of extra hole in 2 sets of D206-559-013 Bearpaws for the US Border Patrol.  
The order will come through today (I think for the DSI9320) Lead-time ONE week if possible,

Thasnk  
Peggy

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**From:** Peggy McDonald [mailto:pmcdonald@dartaero.com]  
**Sent:** Monday, February 13, 2006 9:13 AM  
**To:** 'Holly Menard'  
**Cc:** 'Sian Willems'; 'Bill Beckett'; Dale Trepanier (Dale Trepanier)  
**Subject:** FW: AS350-B3 Bear Paws

Good Morning Holly,

Please issue 2 separate returns for 1. set each of D206-559-013 Bearpaw Kits – One kit from each location below.  
The kit from Bellingham, will include one Bearpaw that is not longer serviceable – Bill is aware.  
The kit from NY has not yet been opened.

There will be no restocking fee. We are in the process of modifying 2 kits and sending them out to the customer.  
(The customer uses custom made Wearplates and they need us to relocate one of the Bearpaw holes to be able to complete the install)

Contact Gene for all information required regarding the return of BOTH kits.  
L3 should send these back prepaid on their courier account

Let me know if you have any questions.

We will also need to process 2 separate replacement orders with DSI 9320 – This will be the DART Service Instruction number to authorize the modification to the Bearpaws. We can work on this later today.

Have a great day.  
Peggy

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**From:** Gene Voorhies [mailto:Gene.Voorhies@L-3com.com]  
**Sent:** Thursday, February 09, 2006 11:21 AM  
**To:** peggym@darths.com  
**Subject:** AS350-B3 Bear Paws

Peggy,

I have just received word from our air branch in Plattsburg that they have received there set of Bear Paws Yesterday.

2/15/2006

Here is the information you request earlier:

Point of Contact for Bellingham Wa.: Jay Williamson or Gene Voorhies

Shipping Address: L-3 Com. Vertex Aerospace LLC  
2037 W. Bakerview Rd. Unit 53 BM,  
Bellingham, Wa. 98226

Point of Contact for Plattsburg NY: Phil Cottam

Shipping Address: L-3 Com. Vertex Aerospace LLC  
214 Connecticut Road  
Plattsburg, NY 12903

If There is any thing else I can assist you in this matter, please do not hesitate to call.

Gene K. Voorhies  
Chief Quality Control Inspector  
L-3 Com. Vertex Aerospace LLC, Bellingham Air and Marine Branch  
DHS, U.S. Customs and Border Protection (CBP)  
Work Phone (360) 734-6090  
Fax (360) 647-7528  
Cell (360) 201-9427

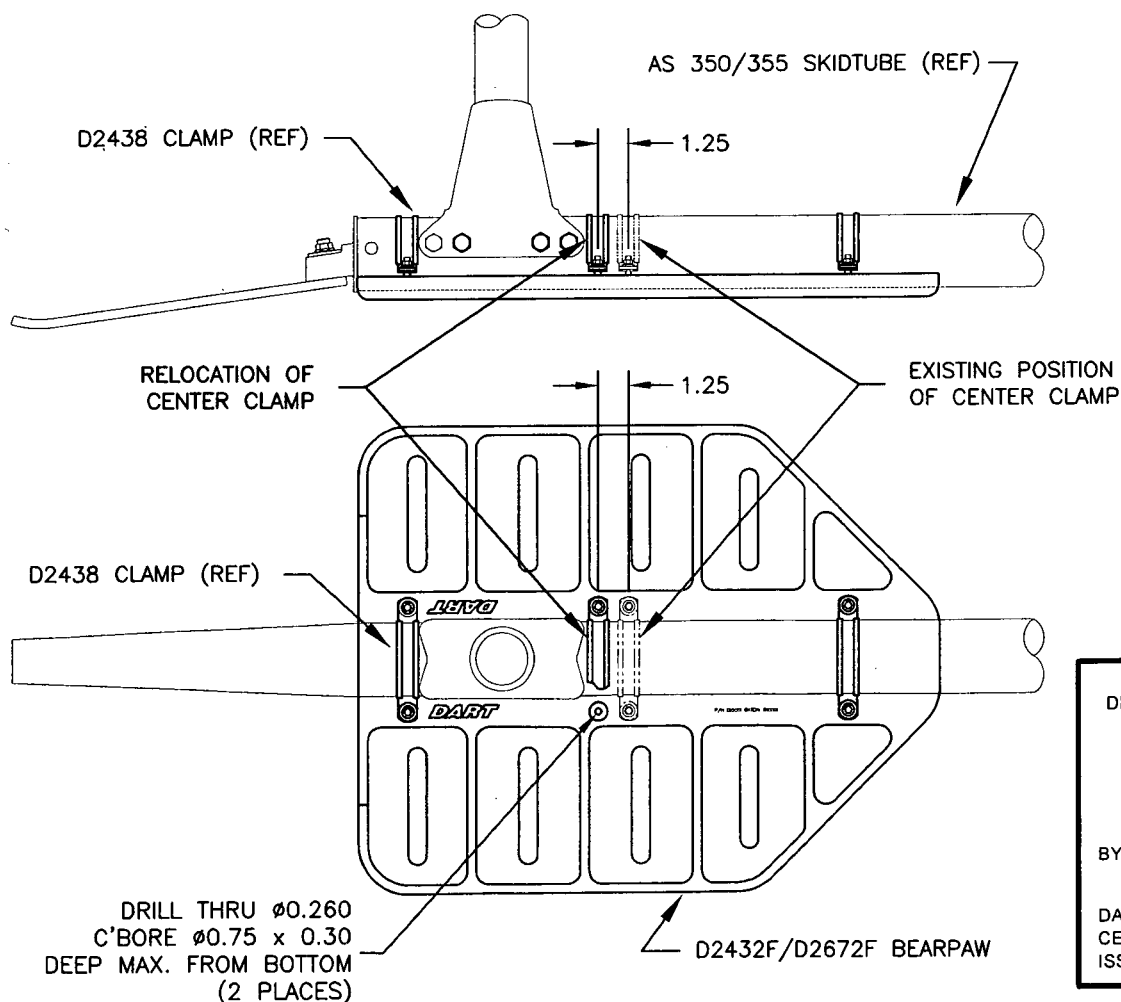


DESIGN #	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. DSI 9320	REV. A SHEET 1 OF 1
DATE 06.02.13		TITLE MOVE CENTER CLAMP HOLES	SCALE 1:1
A	06.02.13	NEW ISSUE	

## DART SERVICE INSTRUCTION

TO AMEND INSTALLATION DRAWING D350-578 REV. E  
REF. CANADIAN STC SH93-4 ISSUE 7  
FAA STC SR00028NY/SR00029NY

IT IS ACCEPTABLE TO RELOCATE THE CENTER CLAMP ON THE D350-578-011/-021 BEARPAW KITS 1.25" AFT AS SHOWN BELOW FOR COMPATIBILITY WITH SOME KITS. DRILL NEW HOLES TO  $\phi 0.260$ " AND COUNTERBORE  $\phi 0.75$ " MAXIMUM TO 0.30" MAXIMUM DEPTH ON THE BOTTOM SIDE OF THE BEARPAWS.



CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 06.02.13  
CERT. NO.: SH93-4  
ISSUE NO.: 7

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DART AEROSPACE LTD		Work Order:	258/2
Description: DSI 9320		Part Number:	DSI 9320
Inspection Dwg:	Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

[illegible]

Measured by: 	Audited by: 	Prototype Approval: N/A
Date: 12-02-16	Date: 06-02-16	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	